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D4895-047
Job Sheet 183262



Part No: D4895-047

Job Qty: 1 ea *2 Jk*

Part Name: Aft Outboard Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/14/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IIP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Waterjet		<i>DR 18/09/18</i>
100	Waterjet	1 pcs	10/5/18	10/5/18	0.00	0.79	Waterjet1		<i>DR 18/09/18</i>
110	CNC Vertical Machining	1 pcs	10/5/18	10/5/18	0.62	2.94	HAAS1-5		<i>KT 2018-10-12</i>
120	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Machining-3		<i>KT 2018-10-12</i>
150	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-3		<i>mm L 18/10/18</i>
160	HandFinish	1 pcs	10/5/18	10/5/18	0.00	0.19	HandFinish1		<i>DR 18/10/18</i>
170	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC7-4		<i>DR 18-10-15</i>
171	Powdercoat	1 pcs	10/5/18	10/5/18	0.00	0.11	Powdercoat1		<i>DR 18-10-15</i>
172	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC3		<i>DR 18-10-15</i>
180	Small Fab	1 pcs	10/5/18	10/5/18	0.00	0.24	Small Fab-8		<i>OCT 17 2018</i>
190	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC5		<i>OCT 17 2018</i>
200	Packaging	1 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2		<i>OCT 17 2018</i>
210	QC21-SA	1 Ea	10/5/18	10/5/18	0.00	0.00	QC21		<i>OCT 17 2018</i>

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	3.0100 ft (3.01 ea)	90-Start up Operation	<i>5083983</i>
D4859-1	Bushing	4 Ea (4 ea)	180-Small Fab	<i>5119038</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X12.000	3	14	0
180-Small Fab	D4859-1	4	7	0

5083983 START 11:20 TEMP 320° FINISH 11:50

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 183262
Description: Aft Outboard Beam		Part Number: D4895-7
Inspection Dwg: D4895	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.55	✓			
	R1.50	+/-0.030	1.50	✓			
	R0.38	+/-0.030	0.380	✓			
	4.63	+/-0.030	4.63	✓			
	5.75	+/-0.030	5.75	✓			
	0.250	+/-0.010	0.250	✓			
	0.150	+/-0.010	0.150	✓			
	3.00	+/-0.030	3.00	✓			
	R0.43	+/-0.030	0.43	✓			
	0.200	+/-0.010	0.200	✓			
	0.750	+/-0.010	0.750	✓			
	Ø0.425	+0.000/-0.002	0.4235	✓			
	6.97	+/-0.030	6.97	✓			
	0.93	+/-0.030	0.930	✓			
	0.85	+/-0.030	0.850	✓			
	1.00	+/-0.030	0.980	✓			
	R0.13	+/-0.030	0.130	✓			
	0.150	+/-0.010	0.150	✓			
	Ø0.377	+0.006/-0.001	0.377	✓			
	3.00	+/-0.030	3.00	✓			
	1.15	+/-0.030	1.15	✓			
	Ø1.00	+/-0.030	1.00	✓			
	2.300	+/-0.005	2.300	✓			
	0.60	+/-0.030	0.600	✓			
	0.80	+/-0.030	0.800	✓			
	3.600	+/-0.005	3.600	✓			
Manual Mill	1.800	+/-0.005	1.800	✓			
	1.75	+/-0.030	1.75	✓			
	3.50	+/-0.030	3.50	✓			
	0.25	+/-0.030	0.240	✓			
	5.50	+/-0.030	5.50	✓			
	12.000	+/-0.005	12.00	✓			
	1.55	+/-0.030	1.55	✓			
	Ø0.465 X 90°	+/-0.010 x 0.5°	0.465 x 90°	✓			
	R0.25	+/-0.030	0.250	✓			
	0.500	+/-0.010	0.500	✓			

Measured by: KS 1	Audited by: [Signature]	Preliminary Approval:
Date: 2018-10-11 9-89	Date: 18/10/12	Date:

Rev	Date	Change	Revised by	Approved
A	14.08.05	New Issue	KJ	[Signature]